
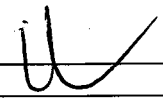


Date: Tuesday, 24/03/2009 7:48:18 AM
User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D350-589-041	
Job Number : 46674		
Estimate Number : 10804		
P.O. Number :	Part Number : D350589041	
This Issue : 24/03/2009 S.O. No. :	Drawing Number : REWORK	
Prsht Rev. : NC	Project Number :	
First Issue : / / Type : SMALL /MED FAB	Drawing Revision :	
Previous Run : 00015	Material :	
Written By : 	Due Date : 31/03/2009	Qty: 1 Um: Each
Checked & Approved By :		
Comment :		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------


1.0	COMPOSITE ASSY	COMPOSITE ASSEMBLY
-----	----------------	--------------------



Comment: COMPOSITE ASSEMBLY

PULL FROM STOCK:
1 X D2991-1 B111160


REMOVE EXISTING DOUBLERS D2992-1

 090324

2.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP




 09-03-24

3.0	COMPOSITE ASSY	COMPOSITE ASSEMBLY
-----	----------------	--------------------




Comment: COMPOSITE ASSEMBLY

BOND NEW DOUBLERS D2992-1 REV.B
AS PER DRWG D2991-1

Epox y Adhesive EA9330 A/B M110170  090325
Doubler D2992-1 B/N B46667  090325
F6778/50550 M108932 2ft  090325


PROCEED TO ASSEMBLE PER BELOW

 090324

4.0	D29911	Side Door
-----	--------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Side Door

B #46674  090326

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 24/03/2009 7:48:18 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D350-589-041

Job Number: 46674

Part Number: D350589041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D24641700

Neoprene Seal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
1	D2464-1700	Foam seal	39669

39669

SS 09/03/24 (X)

6.0

D2585

Mounting Channel



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
3	D2585	Latch clamp	45887

45887

SS 09/03/24 (X)

7.0

D2586

Door Latch



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
3	D2586	Door latch	45554

45554

SS 09/03/24 (X)

8.0

D2621

Latch Plate, 350 Spacepod



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
3	D2621	latch plate	41175

41175

SS 09/03/24 (X)

9.0

D3085041

prop ass'y



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
1	D3085-041	prop ass'y	B38320

B38320

SS 09/03/24 (X)

10.0

MS21042L3

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
6	MS21042L3	Nut	M110399

M110399

SS 09/03/24 (X)

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 24/03/2009 7:48:18 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D350-589-041

Job Number: 46674

Part Number: D350589041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

AN960JD10

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s) -

Pick:

Qty Part number Description
3 AN960JD10 Washer

Batch

M110523



SS 09/03/24 (X)

12.0

MS27039115

Screw



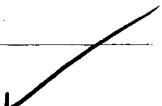
Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s) -

Pick:

Qty Part number Description
3 MS27039-1-15 Screw

Batch

M109321



SS 09/03/24 (X)

13.0

D37211

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) -

Decal

batch: 45492



SS 09/03/24 (X)

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D2991 & IIN D350-589 and install label as per dwg

SS 09/03/24 (X)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick list:

17.0

D38941

Switch Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Switch Plate

Batch: 45526

SS 09/03/25 (X)

W/O:			WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 24/03/2009 7:48:18 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D350-589-041

Job Number: 46674

Part Number: D350589041

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

18.0

D38951

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Batch:

45585

SS 09/03/25 (X)

19.0

D2237

Striker Plate



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty

Part number

Description

Batch

3

D2237

Striker Plate

43938

SS 09/03/25 (X)

20.0

D2589

Keys, Key Chain, 350 Hinge



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty

Part number

Description

Batch

1

D2589

keys, key chain

38814

SS 09/03/25 (X)

21.0

AN34A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty

Part number

Description

Batch

6

AN3-4A

Bolt

M103641

SS 09/03/25 (X)

22.0

MS20470AD45

Rivet, Universal Head



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty

Part number

Description

Batch

6

MS20470AD4-5

Rivet

M69031

SS 09/03/25 (X)

23.0

MS21042L3

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Nut

M16399

SS 09/03/25 (X)

Date: Tuesday, 24/03/2009 7:48:18 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D350-589-041

Job Number: 46674

Part Number: D350589041

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

12 09.03.26

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

CHG # 004.

26.0

QC21

FINAL INSPECTION/W/O RELEASE



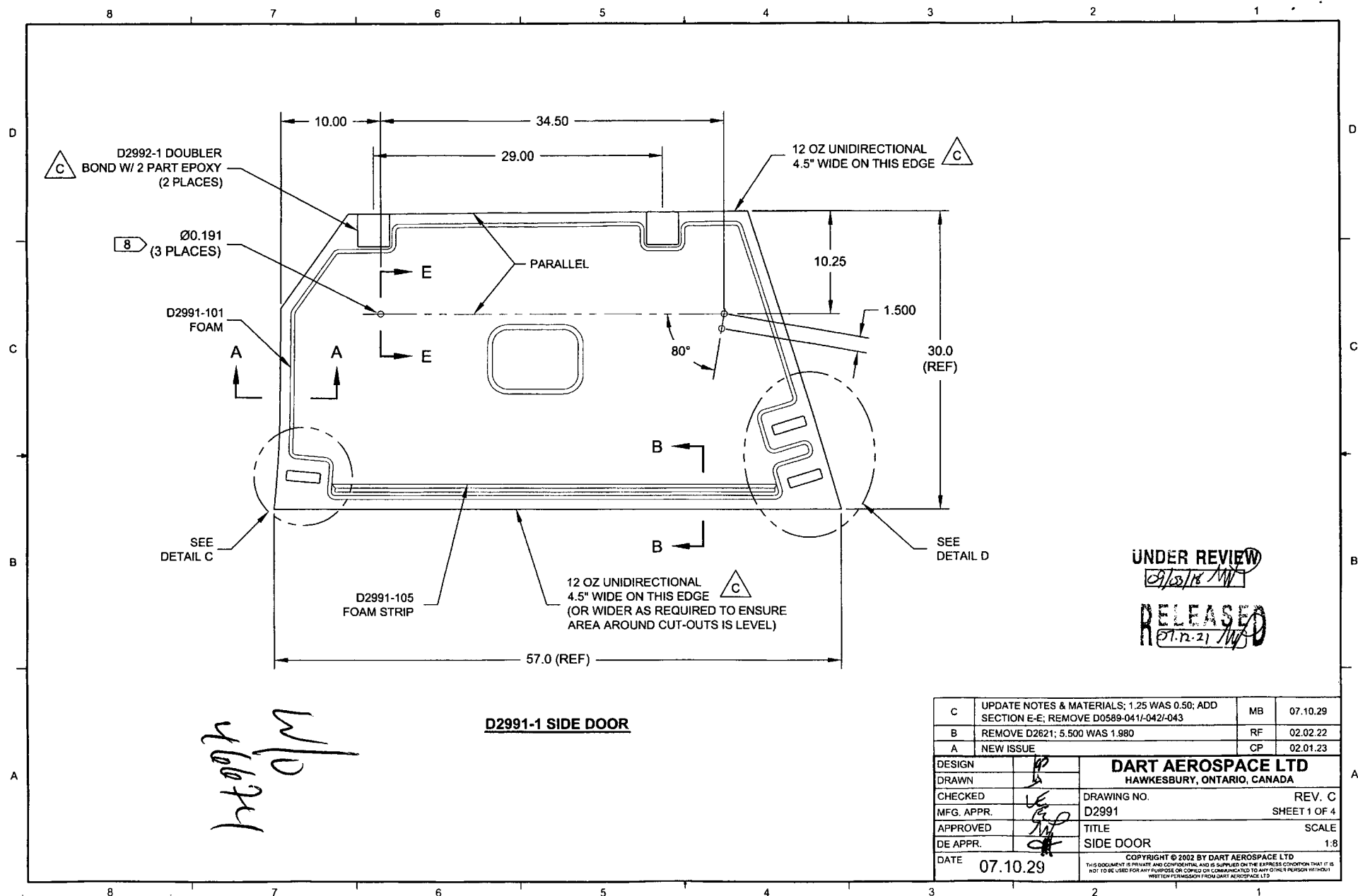
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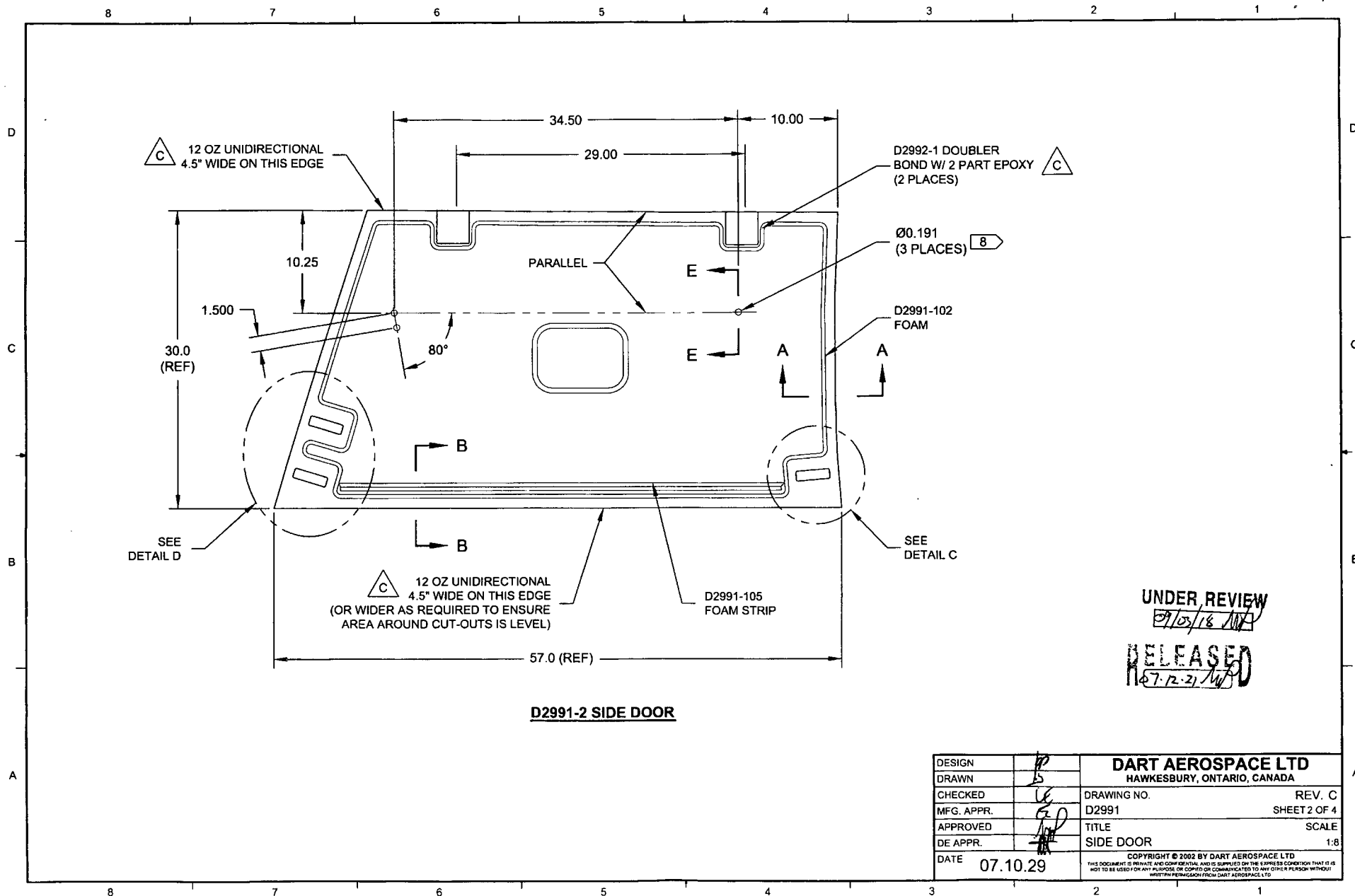
12 09/03/27

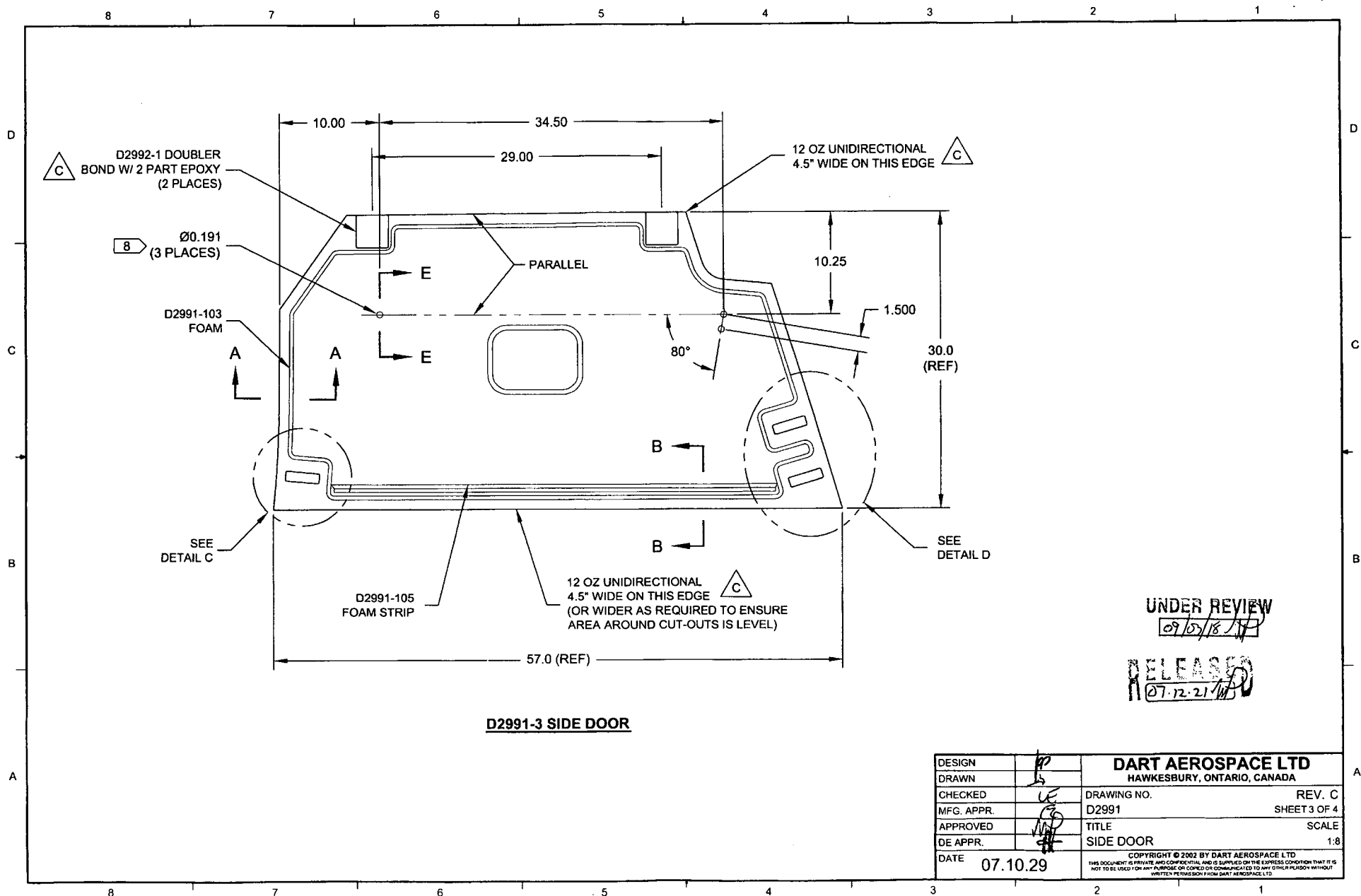
Job Completion



*mk
09-03-25*



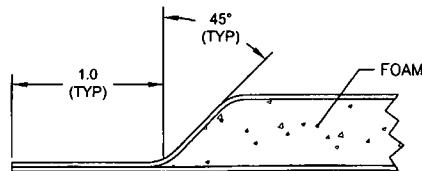




UNDER REVIEW

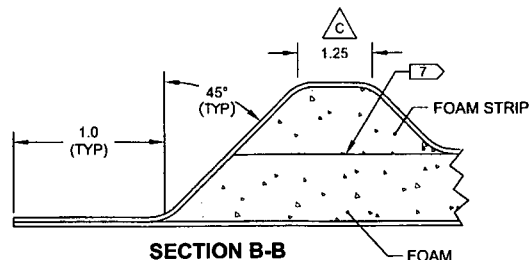
09/05/18 *[Signature]*

RELEASED
07.12.21 *[Signature]*



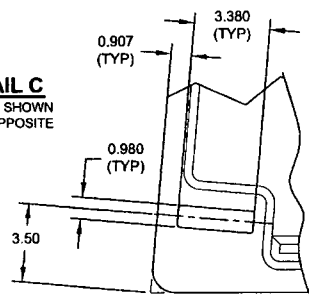
SECTION A-A

NOT TO SCALE
D2991-1/-3 SHOWN
D2991-2 OPPOSITE



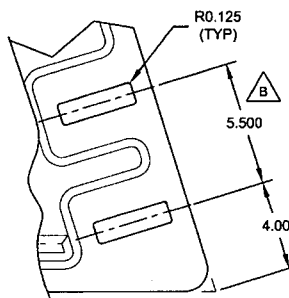
SECTION B-B

ONE EDGE ONLY
NOT TO SCALE, VIEW ROTATED
D2991-1/-3 SHOWN
D2991-2 OPPOSITE



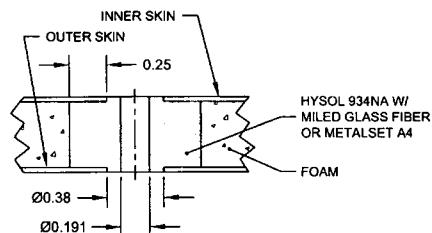
DETAIL C

D2991-1/-3 SHOWN
D2991-2 OPPOSITE



DETAIL D

D2991-1/-3 SHOWN
D2991-2 OPPOSITE



SECTION E-E

TYPICAL Ø0.191
HOLE DETAIL
NOT TO SCALE

NOTES FOR D2991-1/-2/-3

- 1) LAYUP PER QSI 006 AND AS FOLLOWS
- 2) MATERIALS:
RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 3) FINISH INSIDE WITH DUPONT HIGHBUILD PRIMER GREY #1104S OR #1144S
- 4) USE MOLD DT8626 FOR D2991-1 SIDE DOOR
USE MOLD DT8627 FOR D2991-2 SIDE DOOR
USE MOLD DT8626 FOR D2991-3 SIDE DOOR (TRIM PER DT8631)
- 5) ROUTER FOAM CORE USING: DT8628 FOR D2991-1 SIDE DOOR
DT8629 FOR D2991-2 SIDE DOOR
DT8630 FOR D2991-3 SIDE DOOR
- 6) MAIN LAYUP: WHITE GLOSS GELCOAT #GEL 944W005
9 OZ SATIN
9 OZ SATIN
FOAM
FOAM STRIP
9 OZ SATIN
12 OZ UNIDIRECTIONAL (4.5" WIDE, 2 EDGES SHOWN)
9 OZ SATIN
RESIN (35-45% BY WEIGHT)
PEEL PLY
- 7) BOND FOAM CORE USING POLYBOND B46F
- 8) DRILL Ø0.38 HOLE. REMOVE THE FOAM INNER LAYER 0.25 AROUND THE HOLE BETWEEN THE INNER AND OUTER SKINS. APPLY TAPE OR AN EQUIVALENT BACKER TO THE INNER SIDE OF THE HOLES TO PREVENT EPOXY FILLER FROM GOING THROUGH. FILL THE CAVITY BETWEEN THE SKINS COMPLETELY WITH HYSOL 934NA MIXED WITH MILED GLASS FIBERS TO A RATIO OF 10:1 OR METALSET A4. ALLOW THE MATERIAL TO CURE. DRILL Ø0.191 THROUGH, 3 PLACES PER DOOR. SEE SECTION E-E.
- 9) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 10) UNITS: INCHES UNLESS OTHERWISE NOTED
- 11) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 12) IDENTIFICATION: PER D2991-1/-2/-3 PPPs.
- 13) WEIGHT: 9 lbs (TYP)

UNDER REVIEW
07/03/18
RELEASED
07-12-21

DESIGN	lp	DART AEROSPACE LTD	
DRAWN	lp	HAWKESBURY, ONTARIO, CANADA	
CHECKED	lp	DRAWING NO.	REV. C
MFG. APPR.	lp	D2991	SHEET 4 OF 4
APPROVED	lp	TITLE	SCALE
DE APPR.	lp	SIDE DOOR	1:5
DATE	07.10.29	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE-RELATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

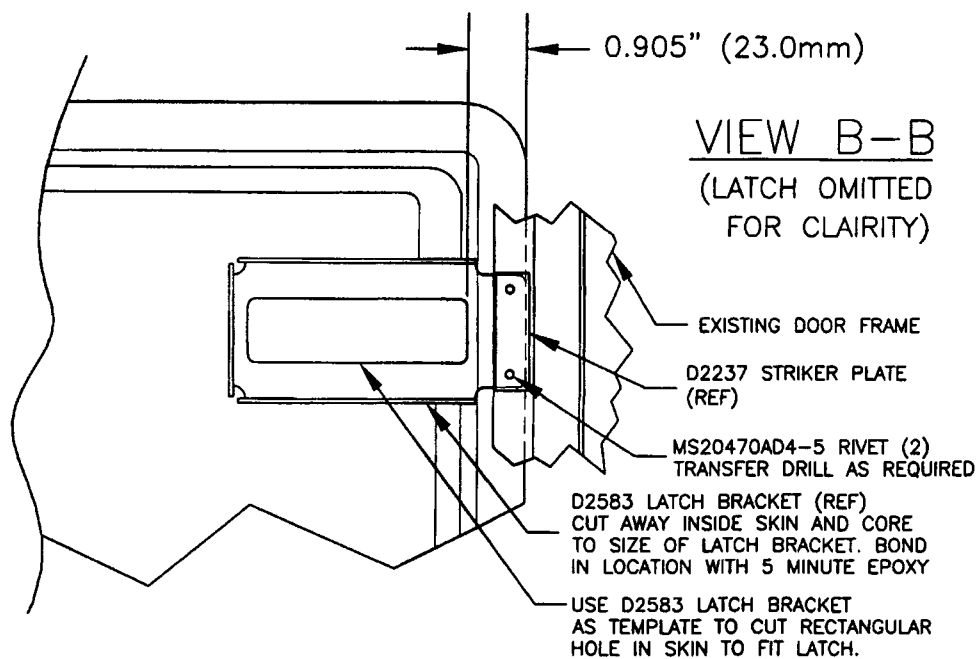
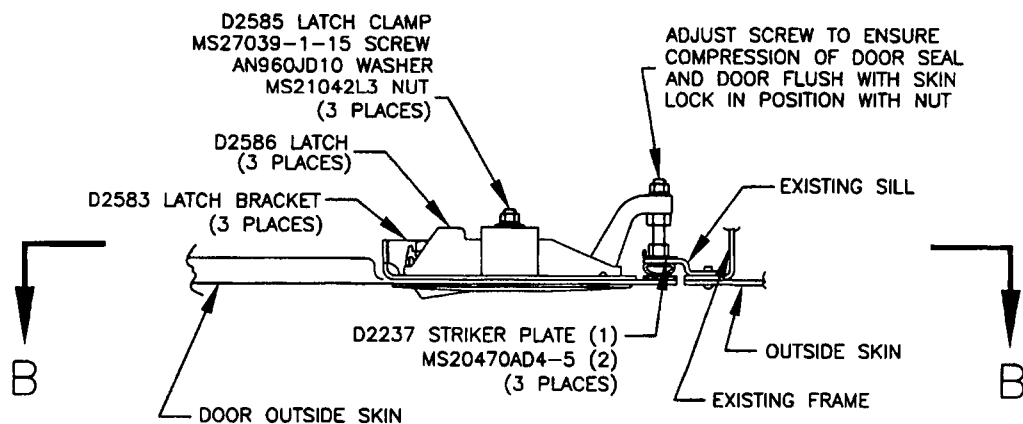
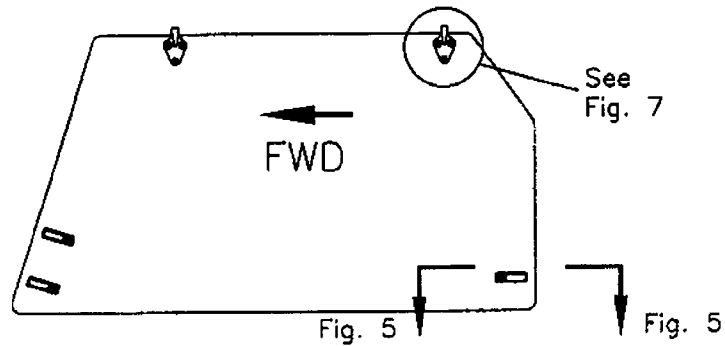
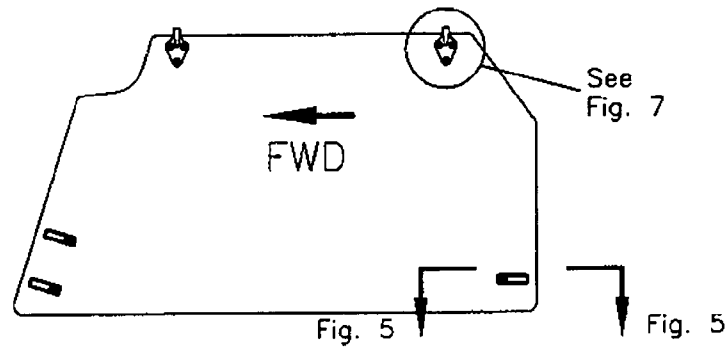


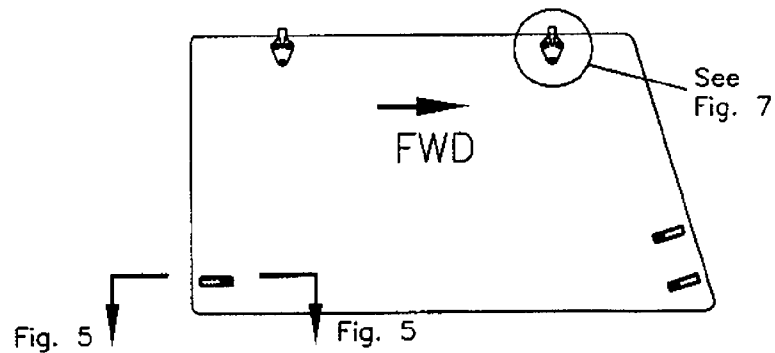
Figure 3: Typical Latch Bracket Installation



D350-589-041 SIDE DOOR ASSEMBLY, LH AS 350



D355-589-043 SIDE DOOR ASSEMBLY, LH AS 355



D350-589-042 SIDE DOOR ASSEMBLY, RH AS 350/355

Figure 4: D350-589-041/-042 and D355-589-043 Side Door Assemblies

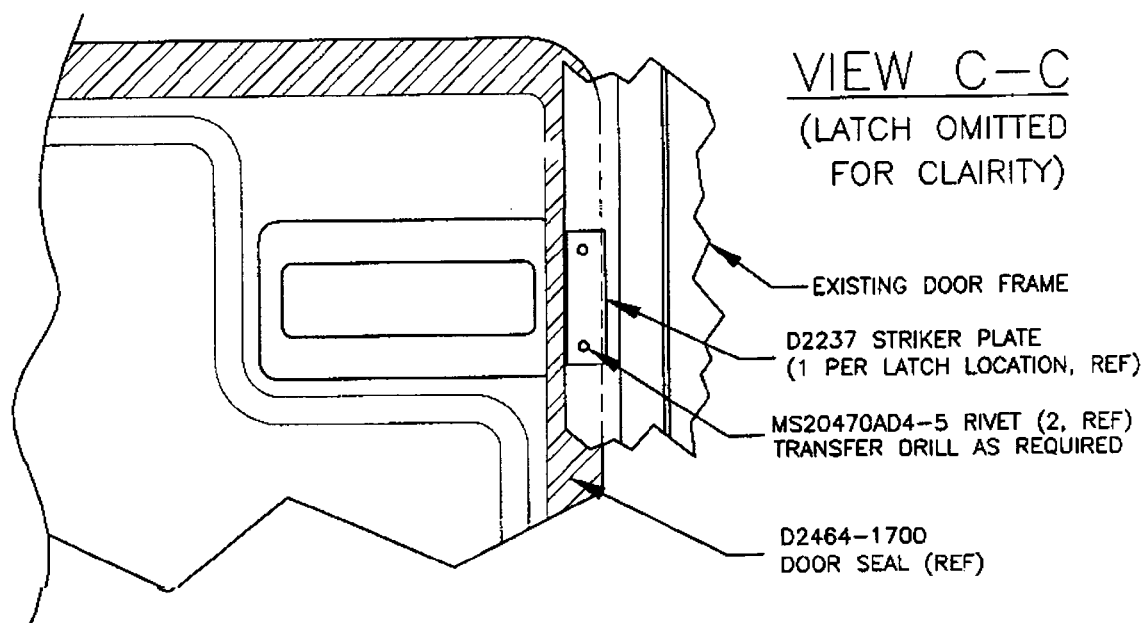
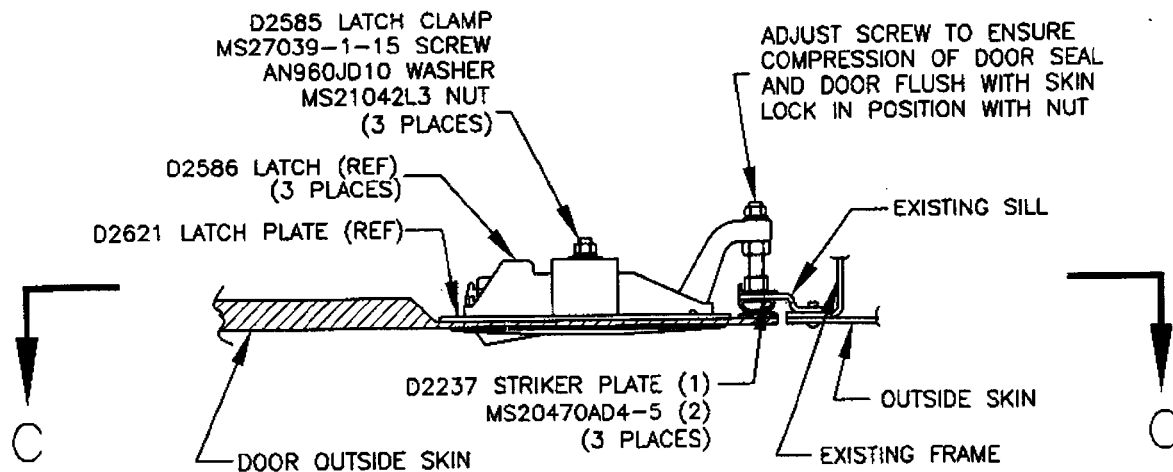


Figure 5: Typical Latch Installation

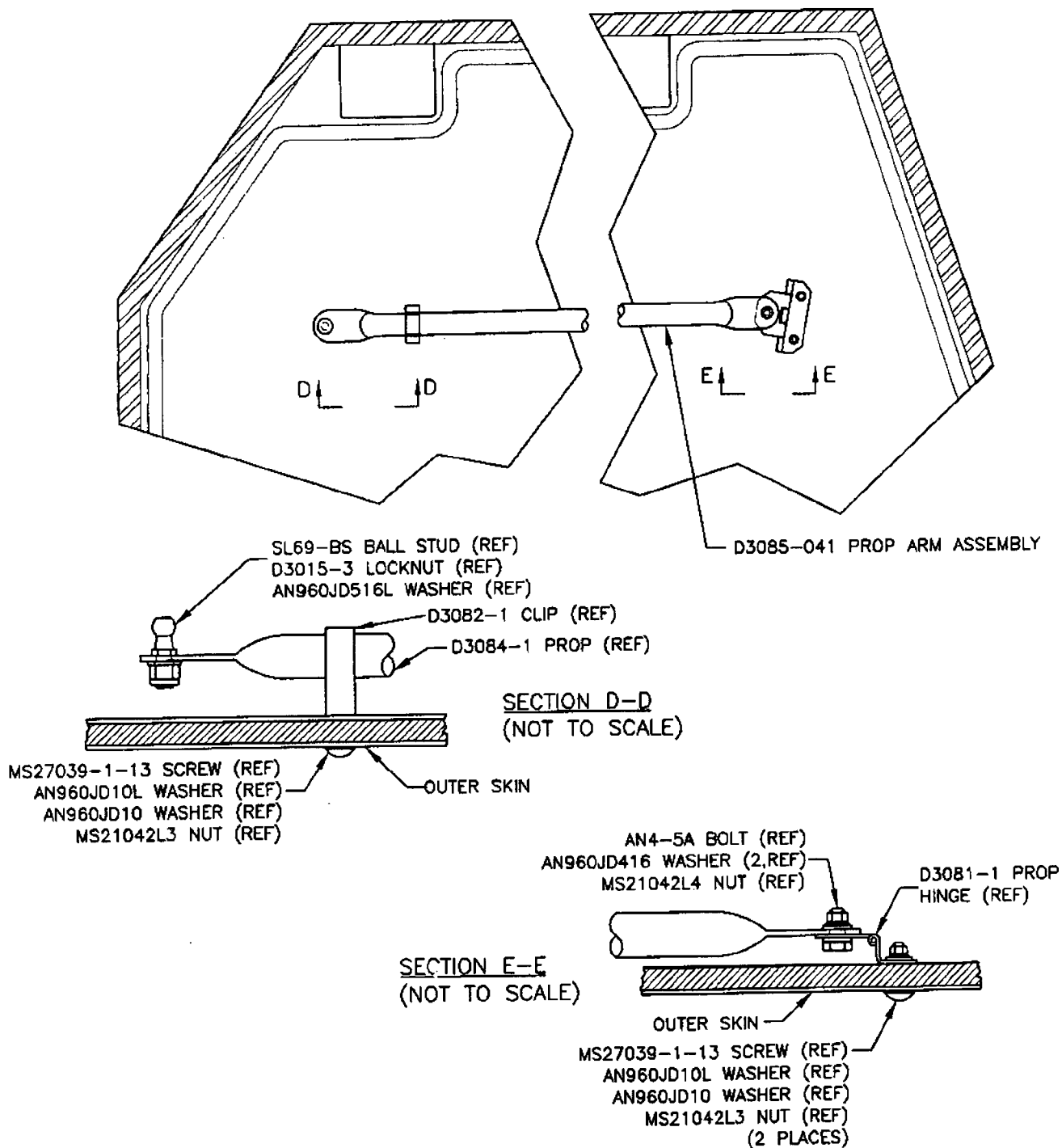


Figure 6: Prop Detail
(Prop is pre-installed, for reference only)

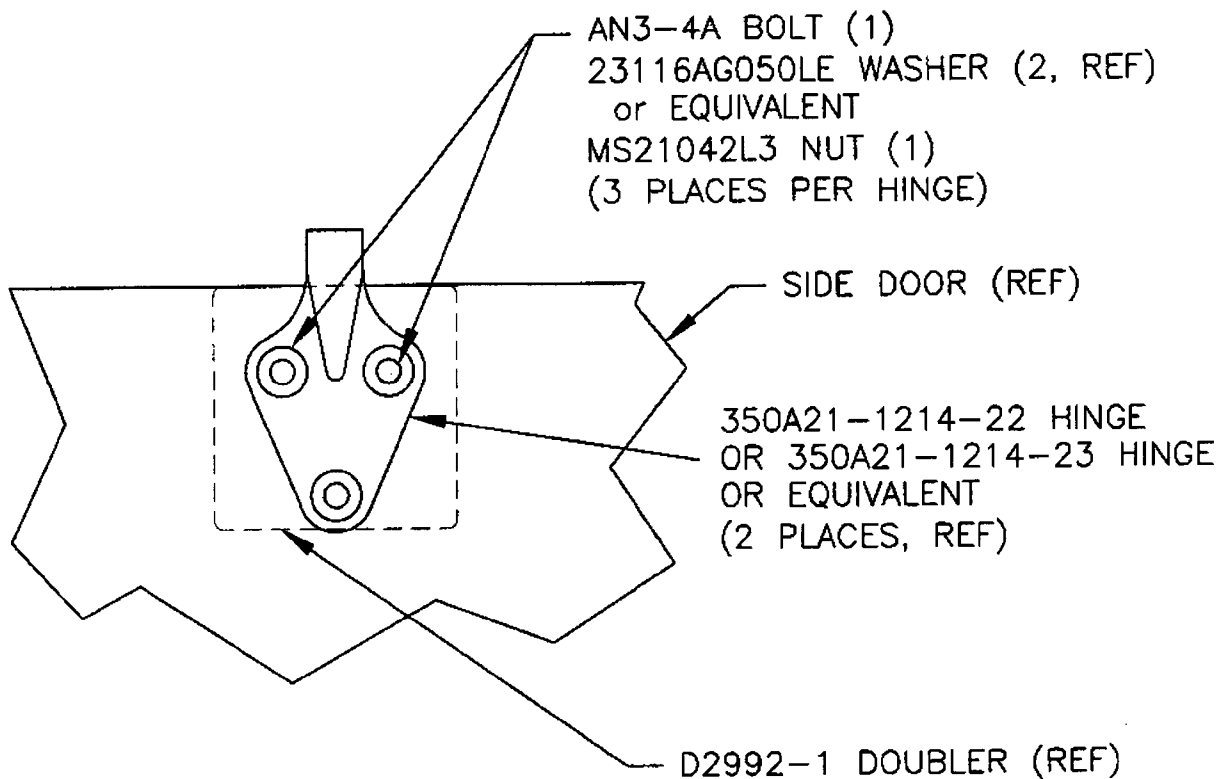


Figure 7: Typical Hinge Detail

3.3 WEIGHT AND BALANCE

The following table outlines the NET weight increase associated with each modification.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-589-011 Side Door Latch Modification Kit	0.31 lb 0.14 Kg	+/-38.0 in +/-0.96 m	+/-11.9 in-lb +/-0.14 m-Kg	+125.0 in +3.17 m	+39.0 in-lb +0.45 m-Kg
D350-589-041 Side Door Assembly, LH AS 350	0 lb 0 kg	N/A	N/A	N/A	N/A
D350-589-042 Side Door Assembly, RH AS 350/355	0 lb 0 kg	N/A	N/A	N/A	N/A
D355-589-043 Side Door Assembly, LH AS 355	0 lb 0 kg	N/A	N/A	N/A	N/A

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Revision: **E**
Date: 02.02.22

Chantal Lavoie

From: Jocelyne Laurin [jlaurin@delastek.com]
Sent: March 24, 2009 10:36 AM
To: 'Chantal Lavoie'
Subject: p/o 8193

Hello Chantal,

Since these were prototypes, no official process sheet was used. Once the prototypes are approved by Dart, then official plannings will be issued. Thank you

Best regards,

Jocelyne Laurin
Service à la Clientèle/Customer Service
Tél: 819-533-5788 ext. 221
Fax: 819-533-3494
jlaurin@delastek.com

-----Message d'origine-----

De : Chantal Lavoie [mailto:clavoie@dartaero.com]

Envoyé : 24 mars 2009 06:24

À : 'Jocelyne Laurin'

Objet : p/o 8193

Jocelyne, would it be possible to get all the paper work for the two prototype door D2991-1 & D2991-2 .
Thanks
Chantal

DART**Purchase Order**

Date Feb 13, 2009	Page 1
Purchase Order Number PO00008193	

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613)632-9577
Fax: (613)632-1053

5974

Vendor Address:

Delastek Composites Inc.
2699 5e Avenue, Local 14, C.P. 123
Grand-Mere, QC G8T 5K7
Phone (819) 533-5788
Fax (819) 533-3494

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VU-DEL001	Feb 13, 2009	N30		Feb 18, 2009

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
1.0000	MOULD MOD	D2991-1 MOULD MOD Comments: MOULD MODIFICATION FOR D2991-1	18/02/2009	No	1,500.000000		1,500.00
1.0000	MOULD MOD	D2991-2 MOULD MOD Comments: MOULD MODIFICATION FOR D2991-2	18/02/2009	No	1,500.000000		1,500.00
1.0000	PROTOTYPE	D2991-1 PROTOTYPE	18/02/2009	No	500.000000		500.00
1.0000	PROTOTYPE	D2991-2 PROTOTYPE	18/02/2009	No	500.000000		500.00
<div style="border: 1px solid black; padding: 5px; width: fit-content; margin: 10px auto;">MATERIAL CERTIFICATION REQ'D UPON DELIVERY</div> <div style="border: 1px solid black; padding: 5px; width: fit-content; margin: 10px auto;">CERTIFICATE OF CONFORMITY REQ'D UPON DELIVERY</div>							
Comments:		Tax Summary: GSTUS 200.00 GSTMEUS 0.00			Less: included tax 0.00 Subtotal 4,000.00 Total tax 200.00 Total purchase order in USD Dollars 4,200.00		
Entered By: CLAYOIE		Approved By:					

MAR 11 2009



Colina



DELASTEK COMPOSITES INC.
2699, 5ième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

INVOICE

Telephone : (819) 533-5788

Warehouse : MAIN

GST/PST: 867834582RT/1023043731TQ0001

Bill To

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200

Contact : Linda Lacelle

Invoice No.	13106-B
Customer No.	DART

Ship To

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200

Contact : Linda Lacelle

Ship Via		F.O.B.		Terms		Salesperson	
EPIC EXPRESS COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship Date	Order Date	Our PO #	Order By	Your PO #		GST/PST #	
11/03/2009	13/02/2009	5974	Chantal Lavoie	PO00008193			
Order Ord Qty	Shipped Quantity	Tax	Item Number	Item Description	Unit Price	Extended Price	
1	1	TPS	DKC-NRC-AERONAUTIQUE	Modification mould D2991-1 As per quote S4-0220	1,500.0000	1,500.00	
1	1	TPS	DKC-NRC-AERONAUTIQUE	Modification mould D2991-2	1,500.0000	1,500.00	
1	1	TPS	DKC-NRC-AERONAUTIQUE	Gabarit	0.0000	0.00	
1	1	TPS	DKC-NRC-AERONAUTIQUE	Prototype D2991-1 B46674 As per quote S4-0220	500.0000	500.00	
1	1	TPS	DKC-NRC-AERONAUTIQUE	Prototype D2991-2 B46680 As per quote S4-0220 VIA KINGSWAY WB #51280350-6	500.0000	500.00	

Print Date	24/03/2009
Print Time	04:14:45 PM
Page#	1

Total Paid	\$ US 0.00
Balance Due	\$ US 4,200.00


Subtotal	4,000.00
Freight	0.00
Sales Tax	TPS 200.00
Invoice Total	\$ US 4,200.00

Prepared By : J.Laurin

Date: Lundi, 2009-03-09 09:53:02
 Utilisateur: Marc Dubé



Feuille de Procédé

Client :	DART Dart Aerospace Ltd.	Nom Dessin :	SIDE DOOR N° D2991-1
Numéro Job :	43698	Numéro Article :	DKC134-0066
Numéro Soumission :	2642	Numéro Dessin :	D2991
Numéro B.A. :		Projet Numéro :	DKC134
Cette fois :	2009-03-09	Révision dessin :	E
Prsht Rev. :	NC	Matériel :	Composites
Prem. fois :	--	Date Dûe :	2009-03-05
Job précédente :		Qté:	1 Udm: UNITE
Écrit par :			
Vérifié & Approuvé par :			
Commentaires :			

Process Sheet Rev.: 00 Création du premier.

Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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1.0	AAC0582	Frekote 700NC N° 38425
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Commentair Qty.:	0.025 GALLON(s)/Unit	Total :	0.025 GALLON(s)
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2.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
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Commentair Setup:	0.00Hrs/ Run:	5.0000Min	Total Run :	0.0833Hrs
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Faire la préparation du moule N° DKO-0094 laisser sécher pendant 3 heures selon le QSI-006 et IG 0009.

Date: 16-2-09

Sceau:



3.0	AAC0273	Gel Coat Blanc N° Gel 944W005
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Commentair Qty.:	1.000 KILOGRAMME(s)/Unit	Total :	1.000 KILOGRAMME(s)
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4.0	AAC0275	Catalyst N° DDM-9
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Commentair Qty.:	0.0250 UNITE(s)/Unit	Total :	0.0250 UNITE(s)
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5.0	AAC0198	UN2055 styrene monomere ST
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Commentair Qty.:	0.014 GALLON(s)/Unit	Total :	0.014 GALLON(s)
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6.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
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Commentair Setup:	0.00Hrs/ Run:	15.0000Min	Total Run :	0.2500Hrs
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Dans une quantité de 0.2 gallon de Gel Coat N° 944W005 ajouter 2% de Catalyst N° DDM-9 et diluer à l'aide de 5% de UN2055 styrene monomere ST

Date: 16-2-09

Sceau:



Temps Début: 9:15

Temps Fin: 9:30

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SIDE DOOR N° D2991-1

Numéro Job: 43698

Numéro Article: DKC134-0066

Numéro Job:



Séq.:

Machine ou Opération:

Description:

7.0

GEL COAT.

APPLICATION DE GEL COAT



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire l'application du gel coat sur le moule N° DKO-0094 selon IG 0019

Date: 16-2-09 Sceau:



8.0

AC0409

Tissu à délaminer Release ply B

Commentair Qty.: 5.43 VERGE(s)/Unit Total : 5.43 VERGE(s)

9.0

AC0407

Wrightlon 5200 Bleu P3

Commentair Qty.: 5.43 VERGE(s)/Unit Total : 5.43 VERGE(s)

10.0

AC0408

Feutre de drainage N° Airweave N 10

Commentair Qty.: 5.43 VERGE(s)/Unit Total : 5.43 VERGE(s)

11.0

AC0752

Stretchlon 200 poche à vide Vert

Commentair Qty.: 12.00 PIED(s)/Unit Total : 12.00 PIED(s)

12.0

AAC0276

Fiberglass 9oz Type "S" N° FG778138-125Y

Commentair Qty.: 7.30 VERGE(s)/Unit Total : 7.30 VERGE(s)

13.0

AAC0443

Fiberglass 12 oz Unidirectional

Commentair Qty.: 4.00 VERGE(s)/Unit Total : 4.00 VERGE(s)

14.0

AC0098

Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 3.0000 RL(s)/Unit Total : 3.0000 RL(s)

15.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs

Tailler le matériel, selon les différents patterns de découpe comme suit:

4 plis de tissus de 9.7 oz.

1 pli de 12 oz. pour tout le contour de la pièce par 5" de large.

3 fois le sac à vide Stretchlon 200.

3 fois le film perforé P-3

3 fois le feutre de drainage

2 fois le tissu à délaminer (non nécessaire lors du bagging du core).

Appliquer le ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le côté non en contact avec le sac à vide.

Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz. tous en même temps, en les superposant les uns sur les autres.

Date: 11-2-09 Sceau:



Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 43698Nom Dessin: SIDE DOOR N° D2991-1
Numéro Article: DKC134-0066

Numéro Job:



Séq.: Machine ou Opération: Description:

16.0 AAC0274 Derakane 411-350 Promoté N° RV411B3020

Commentair Qty.: 1.700 KILOGRAMME(s)/Unit Total: 1.700 KILOGRAMME(s)

17.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0060 UNITE(s)/Unit Total: 0.0060 UNITE(s)

18.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 16-2-09 Heure Début: 12:30 Heure Fin: 12:35 Sceau:



19.0 LAMINAGE. LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DKO-0094 et ensuite imbiber un pli de tissu 9.7 oz.

Recommencer l'opération pour le deuxième pli.

Date: 16-2-09 Heure Début: 12:35 Heure Fin: 12:50 Sceau:



20.0 POCHÉ À VIDE 1 FAIRE LA POCHÉ À VIDE



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs

Installer la poche à vide selon IG 0012.

Laisser sécher pendant 4 heures minimum.

Date: 16-2-09 Sceau:



Curing début: 12:35 Curing Fin: 8:00

21.0 AAC0452 Polybond B46F

Commentair Qty.: 0.143 KIT(s)/Unit Total: 0.143 KIT(s)

22.0 DKC134-0062 Foam Core N° D2991-101 (Porte D2991-1)

Commentair Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SIDE DOOR N° D2991-1

Numéro Job: 43698

Numéro Article: DKC134-0066

Numéro Job:



Séq.:

Machine ou Opération:

Description:

23.0

ASSEMBLAGE 3

ASSEMBLAGE GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Retirez le bagging.

Installer le Foam Core selon IG 0033

Date: 17-2-09 Heure Début: 8:15 Heure Fin: 8:30 Sceau:

24.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide selon IG0012

Laisser sécher pendant 2 heures minimum.

Date: 17-2-09 Sceau:Curing Début: 8:15 Curing Fin: 9:45

25.0

AAC0274

Derakane 411-350 Promoté N° RV411B3020

Commentair Qty.: 1.700 KILOGRAMME(s)/Unit Total : 1.700 KILOGRAMME(s)

26.0

AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0040 UNITE(s)/Unit Total : 0.0040 UNITE(s)

27.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 18-2-09 Heure Début: 8:00 Heure Fin: 8:05 Sceau:

28.0

LAMINAGE

LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage du plis de tissu 12 oz. tout le tour de la porte en prenant bien soin que les deux bandes allant dans le coin droit en bas se superposent

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SIDE DOOR N° D2991-1

Numéro Job: 43698

Numéro Article: DKC134-0066

Numéro Job:



Seq.:

Machine ou Opération:

Description:

Faire le laminage du dernier pli de 9.7 oz.

Date: 18-2-09 Heure Début: 8:05 Heure Fin: 8:35 Sceau:



29.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run: 0.1667Hrs

Faire la poche à vide selon IG 0012

Laisser sécher pendant 4 heures minimum.

Date: 18-2-09 Heure Début: 8:35 Heure Fin: 8:45 Sceau:



Curing Début: 8:05 Curing Fin: 1:30

30.0

DÉMOULAGE 1

DÉMOULAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs

Démouler la pièce en faisant bien attention de ne pas abimer les coins et les "edges". Selon l'instruction générale de fabrication N° IG 0018

Date: 18-2-09 Sceau:



31.0

TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run: 0.5000Hrs

À l'aide du gabarit N° DKC-0618 trimer la pièce en utilisant un router muni d'un couteau 1/4" et d'un "Bushing" 1/16" de mur.

Perçer les "Latch" et les trous de penture selon le dessin N° D2991.

Date: 18-2-09 Sceau:



32.0

AAC0433

Hysol 934NA part A&B (quant kit)

Commentair Qty.: 0.150 KIT(s)/Unit Total: 0.150 KIT(s)

33.0

AAC0673

Fibre de verre Miapoxy 66

Commentair Qty.: 0.0002 GALLON(s)/Unit Total: 0.0002 GALLON(s)

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SIDE DOOR N° D2991-1

Numéro Job: 43698

Numéro Article: DKC134-0066

Numéro Job:



Séq.:

Machine ou Opération:

Description :

34.0

TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

À l'aide du Gabarit N° DK0-0118 Percer les 3 trous de 1/4" Dia.

À l'aide d'une clé Allen et en faisant bien attention de ne pas abimer les Skins de la pièce, venir faire un dégagement de 1/2" Dia dans le Foam Core en tre les Skin intérieur et extérieur.

À l'aide de masking Tape, masquer le trous de la skin extérieur.

À l'aide d'un mélange de résine Hysol 934NA / Fibre courte Miapoxy 66 et d'une seryngue, venir remplir les dégagements de 1/2" Dia préalablement fait dans le foam Core.

Laisser sécher.

Date: 18-2-09 Sceau:

35.0

TRIMAGE

TRIMAGE DE FINITION



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

À l'aide du gabarit N° DK0-0118 Repercer les 3 trous de 1/4" Dia.

Date: 19-2-09 Sceau:

36.0

AAC0433

Hysol 934NA part A&B (quart kit)

Commentair Qty.: 0.125 KIT(s)/Unit Total : 0.125 KIT(s)

37.0

AAC0697

N° D2992-1, Doubler

Commentair Qty.: 2 UNITE(s)/Unit Total : 2 UNITE(s)

38.0

ASSEMBLAGE

ASSEMBLAGE GÉNÉRALE DES PIÈCES



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

À l'aide de l'adhésif N° Hysol 934NA, assembler le doubler N° D2992-1 sur la pièces de composite selon le dessin.

Date: 19-2-09 Sceau:

Utilisateur: Marc Dubé

Feuille de ProcédéClient: DART Dart Aerospace Ltd.
Numéro Job: 43698Nom Dessin: SIDE DOOR N° D2991-1
Numéro Article: DKC134-0066

Numéro Job:



Séq.: Machine ou Opération: Description :

39.0 AAC0683 Dupont Primer N° 7704S

Commentair Qty.: 0.1800 UNITE(s)/Unit Total : 0.1800 UNITE(s)

40.0 AAC0685 Dupont Activator - Reducer Chromabase N° 7775S

Commentair Qty.: 0.0450 UNITE(s)/Unit Total : 0.0450 UNITE(s)

41.0 PRIMER APPLICATION DE PRIMER



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

Appliquer le primer selon I.G. 0008

Date: Sceau:

42.0 INSPECTION 3 INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire l'inspection selon le dessin N° D2991

Date: Heure Début: Heure Fin: Sceau:

43.0 EMBALLAGE EMBALLAGE ET ENTREPOSAGE



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire l'emballage des pièces.

Quantité: Date: Sceau:

Date: Tuesday, 24/03/2009 7:51:04 AM
 User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01	Dart Aerospace Ltd.	Drawing Name	: D350-589-041
Job Number	: 46674			
Estimate Number	: 10804			
P.O. Number	:		Part Number	: D350589041
This Issue	: 24/03/2009	S.O. No. :	Drawing Number	: REWORK
Prsht Rev.	: NC		Project Number	:
First Issue	: 24/03/2009	Type : SMALL /MED FAB	Drawing Revision	:
Previous Run	: 00015		Material	:
Written By	:		Due Date	: 31/03/2009
Checked & Approved By	:		Qty:	1 Um: Each
Comment	:			

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

COMPOSITE ASSY



Comment: COMPOSITE ASSEMBLY

PULL FROM STOCK:

1 X D2991-1 B111160

REMOVE EXISTING DOUBLERS D2992-1

Change
batch # on
Rework.



B09.03.24 ①

Job Completion



CHG # 004
Mike P.

REFERENCE ONLY

New labels @ CHG 004
JU09.03.24

D2991-